, •											
	Work Order ID 58672 Friday, May 14, 2010 8:26:08 AM										Page 1
Item ID: Revision ID:	D3759-1			Accept					Setup Sta	1 18811161 1	
Item Name:	Bushing								Sto	р	
Start Date: Required Date:	5/13/2010 : 5/20/2010	Start Qty: 36.00 Req'd Qty: 36.00	1 1 8 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		Cust Item I Customer:	D:					
Reference:							***		Run Sta		
Approvals:	Process Pla	nn:	Date: 10-5-14	Tooling:	Da	te:					
	QC:		Date:	SPC (Y/N):	Da	te:			Sto	р	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	rision Nbr									
D3759	Rev	Α					•		•		
		Hardinge CNC LATHE	SMALL	0.00							
Hardinge		Memo		0.00			,				
Hardinge CNC Lath	e Small	Hardinge Cl □ Deburr	NC LATHE SMALL⊡Turn ¡	per Folio FA727 and Dwg	3 D3759 JL	Ida	≥121 (36)	·		
		QC2- Inspect parts off m	achine FAI/FAIB	0.00	10/05/21						
QC Quality Control		Мето		0.00							

120 QC QC8- Inspect parts - second check

0.00 \$ 10/05/21

36

Quality Control

0.00

Memo

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Res	solution:	Disposition	n:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		on B	Verific	Verification App		Approval	
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
				10040					
	1 1								ľ

Work Order ID 58672

Friday, May 14, 2010 8:26:08 AM



Page 2

Item ID:

D3759-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Bushing

Required Date: 5/20/2010

5/13/2010

QC:

Start Qty: 36.00

Req'd Qty: 36.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Accept

Date:

Start Run

Stop

Reject

Reject Insp.

Sequence ID/ **Work Center ID**

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:_

Basket GU

Date:

Memo

Set Up/ **Run Hours**

0.00

0.00

Qty Qty Number Stamp

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			-									
· · · · · · · · · · · · · · · · · · ·												
					NCR: Yes No DQA: Date:							
	R	esolution:	Disposition	on:	QA: N/C	Closed:		Date: _	· · · · · · · · · · · · · · · · · · ·			
NCR:			WORK ORE	PER NON-CONFORMA	NCE (NC	R)						
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign		Verification Appr		Approval			
			Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspecto			
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		1				1		1	·			

· Picklist Print

Friday, May 14, 2010 8:26:32 AM

Work Order ID: 58672

Parent Item:

D3759-1

Parent Item Name: Bushing

Comments:

IPP Rev:A 08-03-04 new issue DD verified by: LL



Start Date: 5/13/2010

Required Date: 5/20/2010

Page 1

Start Qty: 36.00

Required Qty: 36.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No		110	f	30.7400	0.0625			· · · · · · · · · · · · · · · · · · ·
											•

304 ROUND BAR 0.375

<u>Location</u>	Loc Qty	Loc Code	
MAT	12.1		
111323	0		
114467	12.1		٠
MAT029	18.64		
113325	3.85		
114356	14.79		

114676

2.6

JL 10/05/21

W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		PAR #:	Fault Cate	jory:	NCR: Yes No DQA: Date:								
	Reso	olution:	Disposition):	_ QA: N/C Clo	sed:		Date: _	***************************************				
NCR:		.	WORK ORDE	R NON-CONFORM	ANCE (NCR)							
DATE	STEP	Description of NC		ion B	Verific	ation	Approval	Approval					
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector				
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							:						
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DART AEROSPACE LTD	Work Order:	58417
Description: Bushing	Part Number:	D3759-1
Inspection Dwg: D3759 Rev: A		Page 1 of 1

		FIRS	STARTICLE	INSPECTION	ON CHE	CKLIST		
			X First Ar	ticle	Proto	type		
i	Drawing imension	Tolerance	Actual Dimensio	Accept	Reject	Method o		mments
	Ø0.375	+0.000/-0.02	20 274					_
	Ø0.257	+0.005/-0.00	01 258					
	0.750	+/-0.010	-152			-		
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	- ···.							
Meas	ured by:	51	Audited by	. 16		Prototype	Approval	N/A
	Date:	10/05/21	Date	17.7	, 	Tototype	Date:	
		12/12/2		10/05/2				N/A
Rev	Date	Change				Rev	ised by	Approved

W/O:			V	ORK OR	DER CHANG	ES		-		,
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
							•			
Part No		PAR #:								
	Resolution:								Date: _	
NCR:		V	VORK OR	DER NON	-CONFORMA	NCE (NCI	?)			
DATE	STEP	Description of NC				viion B Verification			Approval Ap	Approval
	JILI	Section A	Initial Chief Eng	Acti	on Description Chief Eng				Chief Eng	QC Inspecto
						,				
			·							
-										
		•						77		
				•						
										•
NOTE: D	ate & initial	all entries								

D3759-1 BUSHING

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 58672

PA10-5-14

NOTES:
1) MATERIAL: AISI 304/316, STAINLESS STEEL ROD
(REF. DART SPEC M304R)
OR AISI 304/316, STAINLESS STEEL TUBE
(REF. DART SPEC M304TR)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

8

NEW ISSUE AJS 08.03.03 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA *4*35 DRAWN

DRAWING NO. CHECKED REV. A D3759 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE DE APPR. BUSHING NTS DATE

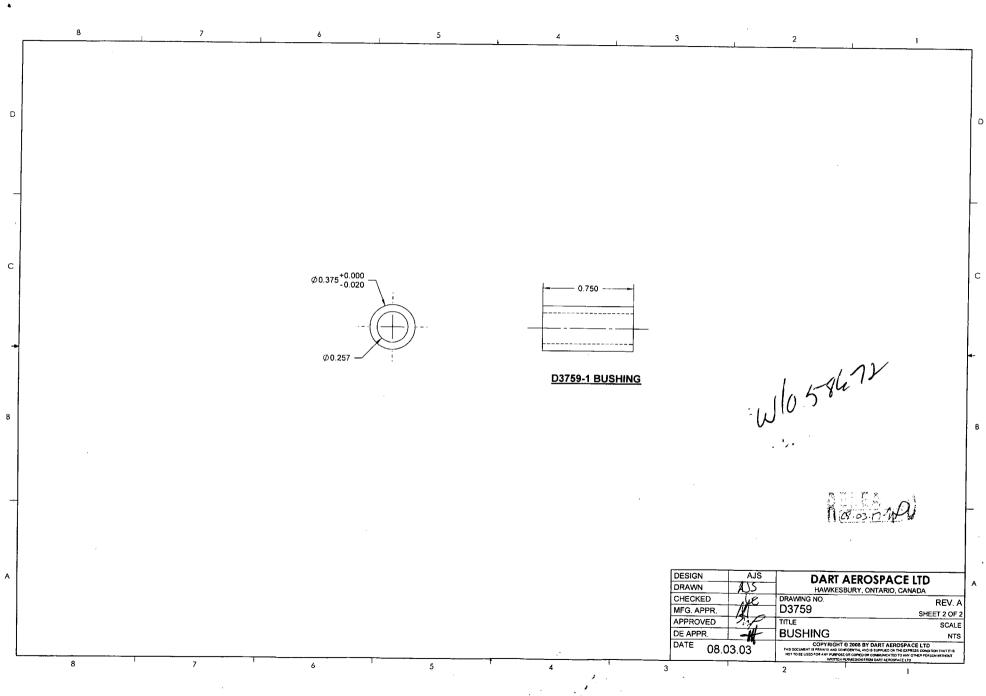
08.03.03

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W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PR	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						1			
				1					
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes 1	No DQA:		Date: _	
	Resolution:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC	Initial		etion B	Verifica	tion	Approval	Approval
	Section A		Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
				-					
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W/O:		WORK ORDER CHANGES								
DATE STEP		PROCEDURE CHANGE			Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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					NCR: Yes No DQA: Date:					
	Res	solution:	Dispositio	QA: N/C	: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)			-	
DATE	STEP	Description of NC Section A			tion B	v	erification	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sigi Da	1 &	Section C	Chief Eng	QC Inspector	
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